



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5331-041

Job Sheet 196389



Part No: D5331-041

Job Qty: 1 pcs

Part Name: Basket Base Assembly, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/12/19

Job Tracking No:

Due Date: 7/12/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV B SHEETS 1,2,4,5,6,7,8 IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM IPP REV:B 17.03.27 add
D4016-7 DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	7/12/19		0.00	15.18	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		DAS
							Large Fab - 6		43
							Large Fab - 7		9-89
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs	7/12/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		DAS
							QC 9 - 43		24
							QC 9 - 50		9-89
							QC 9 - 9		
							QC 9 - 10		
120	QC 5	1 pcs	7/12/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		DAS
							QC 5 - 3		24
							QC 5 - 43		9-89
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

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						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
125 Handfinish - 2-1 Pressure- B4B	1 pcs	7/12/19	0.00	2.34		Handfinish - 2 - 1 - B4B	BEB 19-09-10
						Handfinish - 2 - 2 - B4B	
						Handfinish - 2 - 3 - B4B	
						Handfinish - 2 - 4 - B4B	
130 Powdercoat - 2 White Gl(S)- B4B	1 pcs	7/12/19	0.00	0.53		Powdercoat - 1 - B4B	BEB 19-09-10
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
140 QC 3	1 pcs	7/12/19	0.00	0.00		QC 3 - 10	BEB 19-09-11
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
170 Packaging 3-1 - Stock - B4B	1 pcs	7/12/19	0.00	0.00		Packaging 3 - 1 - B4B	BEB 19-09-11
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 -	

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DAS
59
9-89

					B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	1	7/12/19	0.00	0.00		DAS 21 SEP 11 2019
	pcs					

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: 113888) 1- Assemble ribs and weld as per dwg D5331 using DT10197
 Descriptions: ***inspect before welding mesh*** (54.63 CRITICAL DIMENSION)*** 2- Weld gusset and handle plate as per dwg 3-
 Cut mesh as per dwg D5328-1 4- Tack weld mesh on basket as per dwg D5331 and trim mesh to fit if necessary and trim
 to clear fasteners holes on the ends 5- Weld hinge (6) and Mounting brackets (2) as per dwg D5331 ***Take lid to locate
 hinge and bracket*** On one of the hinge weld stopper D4016-7 as per dwg*** 6- Weld D5325-5 foot as per dwg
 (CRITICAL)

110 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O)

125 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings)

130 - (White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (6) prior to powder
 coat 1ST COAT: START TIME: 11:30 OVEN TEMPERATURE: 350 FINISH TIME: 12:00

*****2nd coat if necessary***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: 11:30

140 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

011711

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581 ✓	Mounting Bracket	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	✓ 5188 852
D3913-15 ✓	Wide Handle Plate	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	✓ 5184 576
D3916-5 ✓	Light Rib	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	✓ 5184 968
D4016-1 ✓	Hinge Half, Base	6 pcs (6 ea) ✓	100-Large Fab - Basket - 1	✓ 5188 922
D4016-7 ✓	Stop	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	✓ 5097165
D4021-1 ✓	Handle Plate	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	✓ 5192 406
D5325-041 ✓	Rib Assembly	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	✓ 5150 825
D5325-3 ✓	Light Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	✓ 5192 226
D5325-5 ✓	Foot	4 pcs (4 ea) ✓	100-Large Fab - Basket - 1	✓ 5154196
D5326-041 ✓	Rib Assembly	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	✓ 5126 564
D5326-043 ✓	Rib Assembly	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	✓ 5192 445
D5327-1 ✓	Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	✓ 5138 436
D5327-11 ✓	Rib	4 pcs (4 ea) ✓	100-Large Fab - Basket - 1	✓ 5190 925
D5327-13 ✓	Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	✓ 5067675
D5327-15 ✓	Cap	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	✓ 5108 289
D5327-3 ✓	Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	✓ 5127 015
D5327-5 ✓	Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	✓ 5127 616
D5327-7 ✓	Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	✓ 5127 694
D5327-9 ✓	Rib	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	✓ 5127 060
D5328-3 ✓	Mesh Base, Aft	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	✓ 5144 989
D5328-5 ✓	Mesh Base, Fwd	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	✓ 5118 091
D5329-1 ✓	Gusset	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	✓ 5089 969
D5330-1 ✓	Handle Plate	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	✓ 5209 383
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	✓ 5188 430

5194 468

DAS
43
9-80

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	72	0
	D3913-15	1	28	0
	D3916-5	2	21	0
	D4016-1	6	52	0
	D4016-7	1	6	0
	D4021-1	1	12	0
	D5325-041	1	2	0
	D5325-3	1	0	0 ✓
	D5325-5	4	4	0
	D5326-041	1	5	0
	D5326-043	1	0	0 ✓
	D5327-1	1	2	0
	D5327-11	4	6	0
	D5327-13	1	5	0
	D5327-15	1	11	0
	D5327-3	1	1	0
	D5327-5	1	1	0
	D5327-7	1	1	0
	D5327-9	2	2	0
	D5328-3	1	5	0
	D5328-5	1	3	0
	D5329-1	2	0	0 =
	D5330-1	2	0	0 =
	M304EX0.75-16F	32	1,020	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QSI042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
☐	☐	☐	☐
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
☐	☐	☐	☐
Crushing	BOM/Route	Grain Direction	Drawing
☐	☐	☐	☐
Cracks	Broken/Damage/Defect	Weld	Finish
☐	☐	☐	☐
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
☐	☐	☐	☐
Marks/Chatter	Drill Holes	Out of Sequence	Misread
☐	☐	☐	☐
Mislabeled	Fit/Function	Off-set/Set-up	
☐	☐	☐	

Other/Details: _____